

## Work Order ID 60027

Tuesday, June 22, 2010 3:25:50 PM



Page 1

Item ID: D4047-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 6/22/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: M Date: 10-06-29 Pooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4047	A								

100



Large Fab

Memo

0.00

SAD 10-06-29

(2)

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

Swl06124

(2)

120

Identify as per dwg & Stock Location: WJ A

0.00

Packaging

Memo

Packaging

SAD  
10-06-29

(2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 60027**

Tuesday, June 22, 2010 3:25:50 PM



Page 2

Item ID: D4047-1

Accept



Setup

Start



Revision ID:

Item Name: Rib

Stop



Start Date: 6/22/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC21- Final Inspection - Work Order Release

0.00

10/06/28 JX

QC

Quality Control

Memo

0.00

Colo 125

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

Tuesday, June 22, 2010 3:25:54 PM

Page 1

**Work Order ID:** 60027**Parent Item:** D4047-1**Parent Item Name:** Rib**Start Date:** 6/22/2010**Required Date:** 7/30/2010**Start Qty:** 2.00**Required Qty:** 2.00**Comments:** IPP RevA: new issue DD 10/01/06 verified by:EC  
revA DD 10.02.18 verified by:EC

IPP Rev:B as per dwg

<b>Component Item ID/ Item Name</b>	<b>Replacement Item ID</b>	<b>Mfg/ Purch</b>	<b>Bin Item</b>	<b>Primary Location</b>	<b>Last Location</b>	<b>Route Seq ID</b>	<b>Unit of Measure</b>	<b>Qty on Hand</b>	<b>Qty per Kit</b>	<b>Total Qty</b>	<b>Qty Issued</b>	<b>Date Issued</b>	<b>Status</b>
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M304TS0.750W.049 Purchased No 100 f 446.7945 5.333 11.22737



304 SQ Tube .75x.75x.049W



SAO 10-06-24

<b>Location</b>	<b>Loc Qty</b>	<b>Loc Code</b>
MAT	146.7944919	
113763	0	
114323	28.3020789	
114677	14.34201	
114835	104.150403	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	300	
114992	300	

11.2273

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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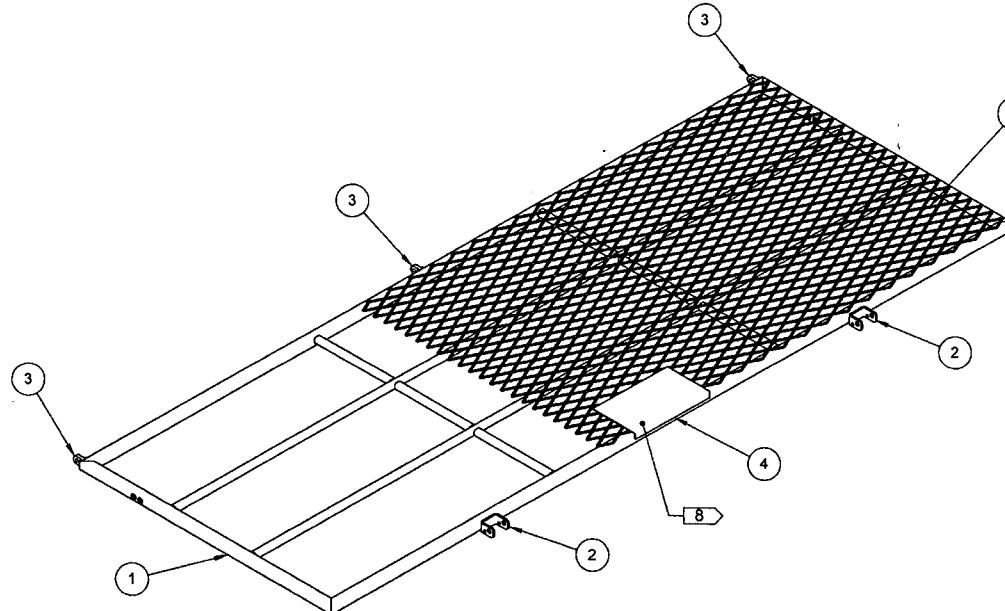
1

D

C

B

A



**D4047-041 SHORT BASKET LID ASSY**  
(MESH SHOWN LOCALLY FOR CLARITY)

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.17 lbs APPROX
- 8) APPL BLACK ANTI-SKID PAINT TO TOP SURFACE OF MESH, EXCEPT ON D4021-3 LABEL PLATE  
PER DART QSI 005 4.4

ITEM	QTY	P/N	DESCRIPTION
	X	D4047-041	SHORT BASKET LID ASSY
1	1	D4047-101	LID FRAME ASSY
2	2	D2581	MOUNTING BRACKET
3	3	D4016-3	HINGE HALF, LID
4	1	D4021-3	LABEL PLATE
5	1	D4046-7	MESH

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 60027  
*Bd 10-6-22*

**RELEASED**  
2010-02-16  
*NP*

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>90</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>DA</i>	D4047	SHEET 1 OF 6
APPROVED	<i>mg</i>	TITLE	SCALE
DE APPR.	<i>-</i>	SHORT BASKET LID ASSY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS ISSUED OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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A

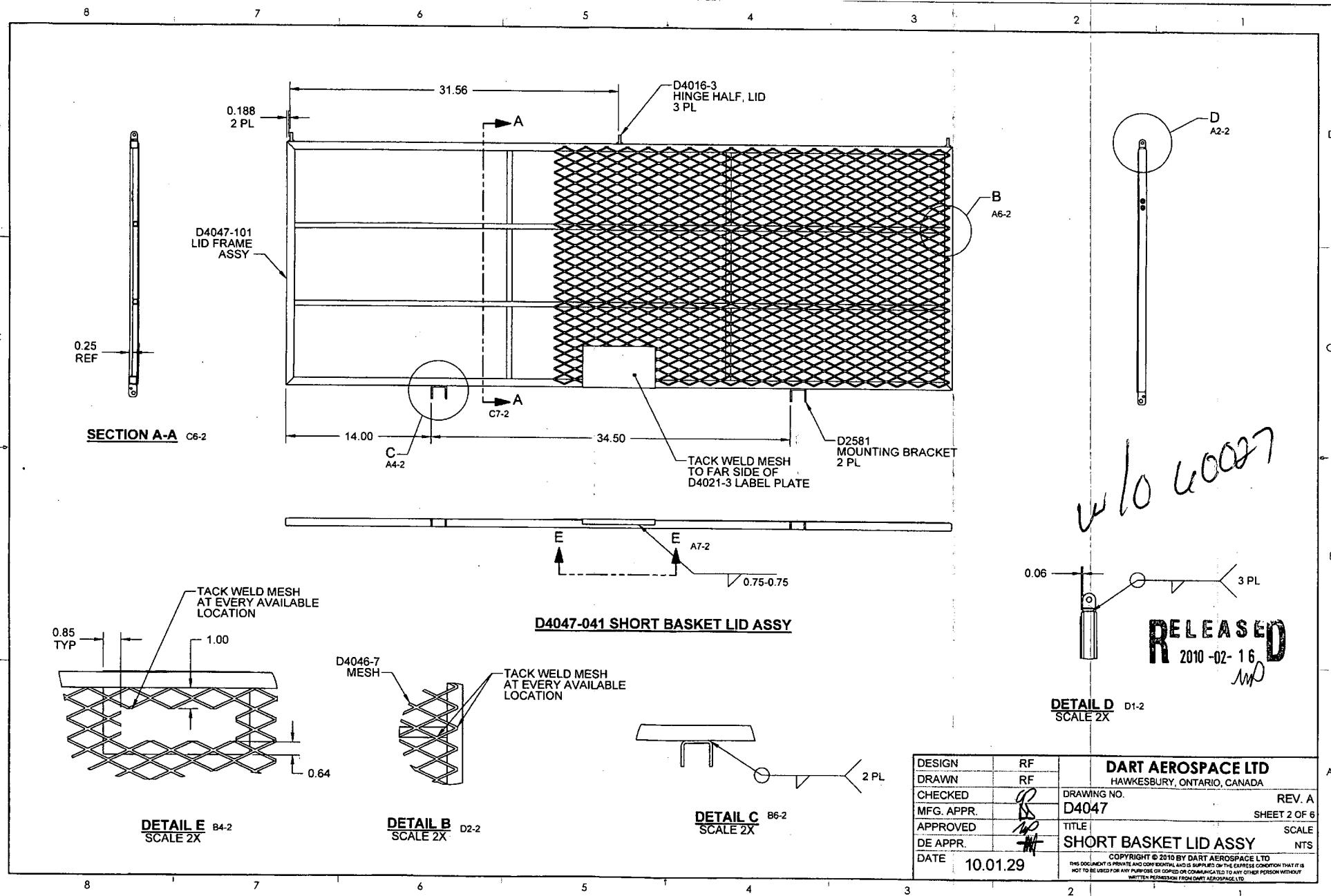
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



July 4, 2007

RELEASED  
2010-02-16

16 2010-02-16

**DETAIL D** D1-3  
SCALE 2X

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	<i>R</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>DS</i>	D4047	SHEET 2 OF 6	
APPROVED	<i>WD</i>	TITLE	SCALE	
DE APPR.	<del><i>WD</i></del>	SHORT BASKET LID ASSY NTS		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

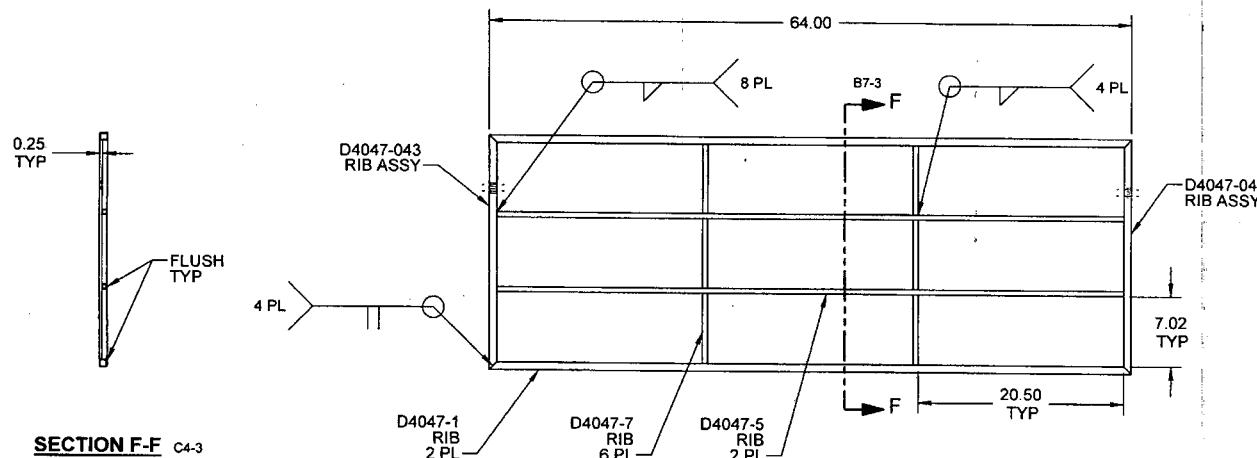
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NOTE: Date & initial all entries

8 1 7 6 1 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	-101		LID FRAME ASSY
X	D4047-101		
1	2	D4047-043	RIB ASSEMBLY
2	2	D4047-1	RIB
3	2	D4047-5	RIB
4	6	D4047-7	RIB



D4047-101 LID FRAME ASSY

W/0 60027

RELEASED  
2010-02-16

- NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 10.33 lbs  
 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	10	D4047	SHEET 3 OF 6
APPROVED	10	TITLE	SCALE
DE APPR.	10	SHORT BASKET LID ASSY	NTS
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8 1 7 6 1 5 4 3 2 1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA \_\_\_\_\_ Date: \_\_\_\_\_

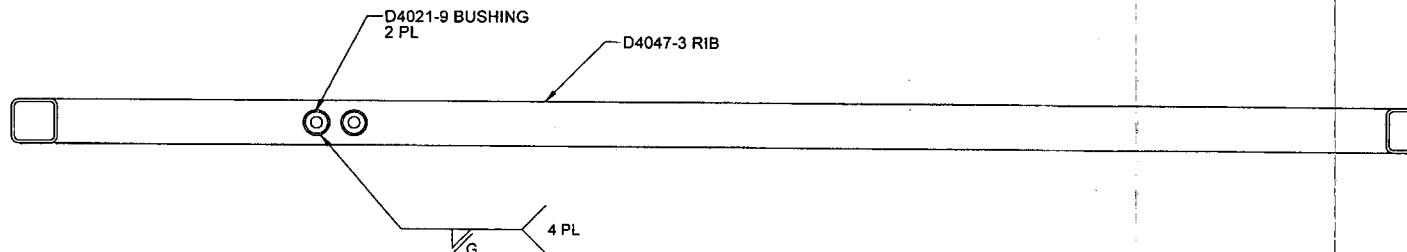
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -043	P/N	DESCRIPTION
X	D4047-043	RIB ASSEMBLY	
1	1	D4047-3	RIB
2	2	D4021-9	BUSHING



D4047-043 RIB ASSEMBLY

w/o 60027

RELEASED  
2010-02-16  
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.88 lbs
- 8) WELD PER DART QSI 004

8 7 6 5 4 3 2 1

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CHECKED	90	DRAWING NO.
MFG. APPR.	10	REV. A
APPROVED	10	SHEET 4 OF 6
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	10	SCALE
	10	NTS
DATE	10.01.29	SHORT BASKET LID ASSY

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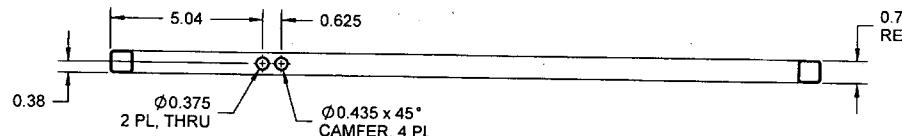
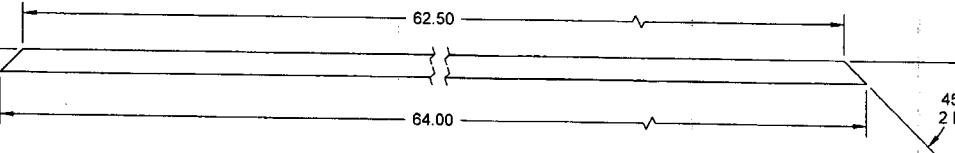
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0.75  
REFD4047-1 RIBD4047-3 RIB

W6 60027

RELEASED  
2010-02-16  
MP

## NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL  
REF DART SPEC: M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4047-1: 2.63 lbs  
D4047-3: 0.84 lbs

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	PP	DRAWING NO.
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APPROVED	MM	SHEET 5 OF 6
DE APPR.	MM	TITLE
DATE	10.01.29	SCALE
		NTS

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8 1 7 6 5 4 3 2 1 0

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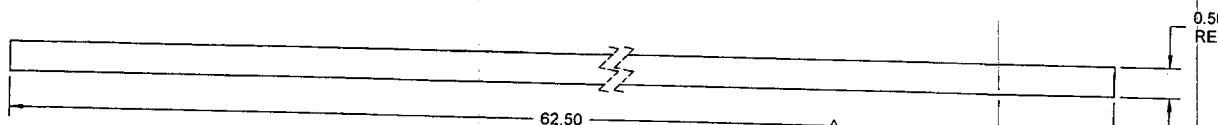
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8 7 6 5 4 3 2 1

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D



D4047-5 RIB

C

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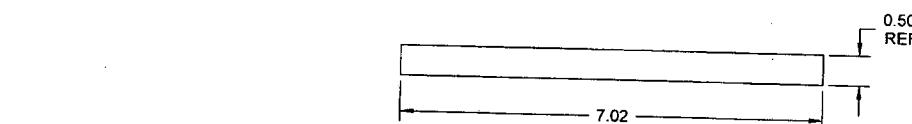
B

A

A

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4047-5: 1.44 lbs  
D4047-7: 0.16 lbs



D4047-7 RIB

W6 60027

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2010-02-16  
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DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	RP	DRAWING NO.
MFG. APPR.	NA	REV. A
APPROVED	MP	D4047
DE APPR.	MP	SHEET 6 OF 6
DATE	10.01.29	TITLE
		SHORT BASKET LID ASSY
		SCALE
		NTS

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8 7 6 5 4 3 2 1

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